

Work Order ID 52654-2



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October 5, 2009 2:52:58 PM

Item ID: D3934-041

Revision ID: A

Item Name: Clip Assembly

Start Date: 06/10/2009 Start Qty: 10.00

Required Date: 13/10/2009 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: *B*

Date: 09-10-5 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3934

RevA

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3934

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

m-k 09/10/13



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B 9-10-8

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Item ID: D3934-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Clip Assembly

Start Date: 06/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

27 502/10/13

count

(132)

✓

QC

Memo

0.00

Quality Control

130

Memo

0.00

88 09/10/15

32

✓

Brake NC

Brake NC

1- Bend as per dwg D3934

0.00

140

QC5- Inspect part completeness to step on W/O

0.00

27 502/10/15

count

(132)

✓

QC

Memo

0.00

Quality Control

Work Order ID 52654



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Item ID: D3934-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Clip Assembly

Start Date: 06/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Small Fab

Memo

1-C'sink and assemble as per dwg D3934

0.00

0.00

Small Fab

9/10/14 *9/10/15* *32*

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

27 Sept 14 *27 Sept 15*

10/10/14 *10/10/15*

170



Packaging

Packaging

Identify as per dwg & Stock Location: *13913*

Memo

0.00

0.00

9/10/14 *9/10/15* *19*

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Item ID: D3934-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Clip Assembly

Start Date: 06/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/19 *[Signature]*

MF

09-10-16

Picklist Print

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Page 1

Work Order ID: 52654

Parent Item: D3934-041RevA

Parent Item Name: Clip Assembly

Comments:

Start Date: 06/10/2009

Required Date: 13/10/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

150

sf

183.2904

0.2211

1075



304/316 .040 Sheet

13910-8

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

183.2904474

110076

31.73

111571

12.1938474

112567

139.3666

110076

MS21075L3

Purchased

No

150

Each

131.0000

10.0000



Nutplate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

131

109068

12

109371

39

110704

37

111477

2

112640

20

112690

2117

19

9/10/15

Picklist Print

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Work Order ID: 52654



Parent Item: D3934-041RevA

Parent Item Name: Clip Assembly

Start Date: 06/10/2009

Required Date: 13/10/2009

Start Qty: 10.00

Required Qty: 10.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD3-3		Purchased	No			100	Each	6,899.000	20.0000			
Rivet												

Handwritten signature
 509/10/15

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST

6899

1563

0

19099

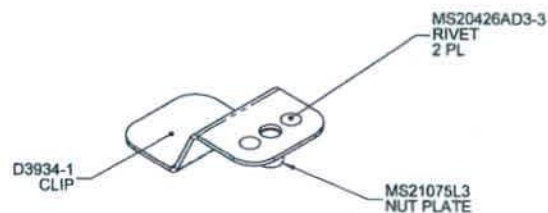
4776

7681

2123

~~69~~
 38

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3934-041	CLIP ASSEMBLY
10	1	D3934-1	CLIP
20	1	MS21075L3	NUT PLATE
21	2	MS20426AD3-3	RIVET



D3934-041 CLIP ASSEMBLY

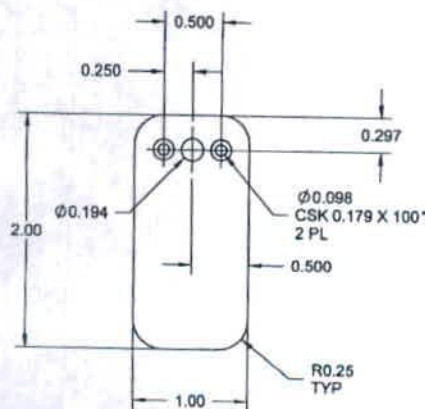
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52654

RELEASED
09/05/05

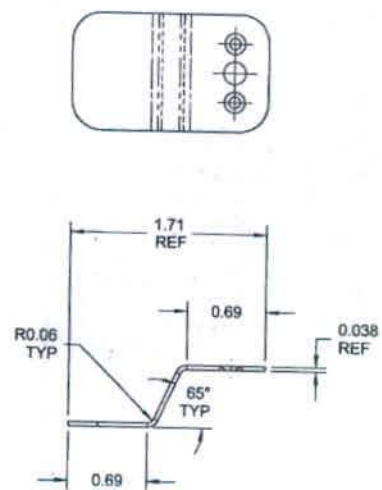
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3934-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs

A		NEW ISSUE		PH	09 04 16
REV.	DESCRIPTION			BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			REV. A	
DRAWN				SHEET 1 OF 2	
CHECKED	DRAWING NO. D3934			SCALE	
MFG. APPR.	TITLE			NTS	
APPROVED	CLIP ASSEMBLY				
DE APPR.	DATE 09.04.16			COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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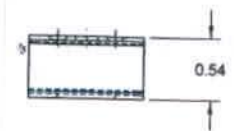
D3934-1F FLAT PATTERN



D3934-1 CLIP
(MAKE FROM D3934-1F)



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52654



RELEASED
69/12/85 MPA

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
20 GAUGE (0.038 THICK)
REF DART SPEC M304S20GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.02 lbs

DESIGN	PA	DART AEROSPACE LTD	
DRAWN	PA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PA	DRAWING NO.	REV. A
MFG. APPR.	PA	D3934	SHEET 2 OF 2
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	CLIP ASSEMBLY	NTS
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